

Date: Wednesday, 3/21/2007 3:40:54 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP SPACER
Job Number : 31407C	
Estimate Number : 10354	
P.O. Number : <i>N/A</i>	Part Number : D2322
This Issue : 3/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2322 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 30813C	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 4/10/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 05-11-07 JLM	
Est Rev:B Now on Waterjet 06-07-03 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



Comment: Qty.: 0.2132 sf(s)/Unit Total : 4.2630 sf(s)  
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick  
 (M2024T3S.040)  
 Identify as D2322  
 Batch: *1104025 ml 07 06 16*

*20*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 1-Cut as per Dwg D2322  
 Dwg Rev: *C*  
 Prog Rev: *C*

*ml 07 06 16*

*20*

2-Debur if necessary

*ml 07-06-25*

*20*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ml 07 06 16*

*20*

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*ml 07/06/18*

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE  
 Form as per Dwg D2322

*S/S 07/06/29*

*20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 8/10/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/21/2007 3:40:54 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 31407C

Part Number: D2322

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/06/29

(470) counted

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FZ 07/06/29 (20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EP 07/07/03 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

EP 07/07/03 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(20) R 07/07/03

Job Completion



CU 07-0703

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
Bw		CP		REV. C	
CHECKED	KE	APPROVED	WHT	DRAWING NO.	SHEET 1 OF 1
DATE	98.09.29	TITLE		SCALE	
		STEP SPACER		1:2	
A	94.10.14	NEW ISSUE			
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001			

RELEASED  
98.10.08 DS

UNDER REVIEW

01.03.15 GP

DESIGN OK, BUT CHECK WITH  
JTS BEFORE MANUFACTURE

OK GP 01/11/09

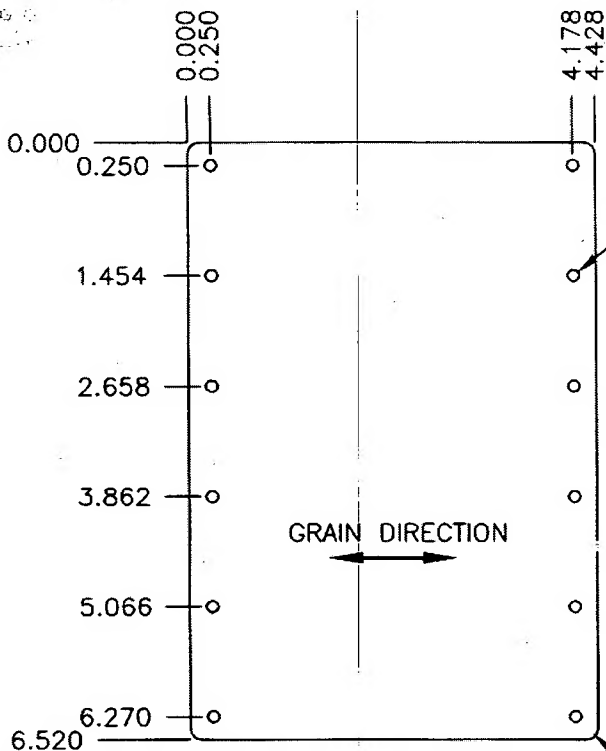
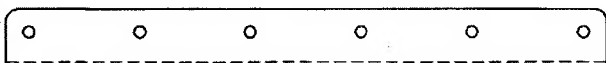
KE 98.09.06

R0.125  
(TYP 4 PLACES)

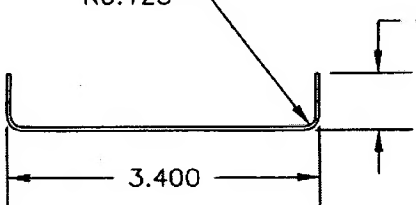
Ø0.128 (TYP 12 PLACES)

GRAIN DIRECTION

FLAT LAYOUT



0.62



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 314076